

Shp Sept. 14

Work Order ID 73640

Thursday, September 08, 2011 1:22:39 PM



Item ID: D3043-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment LH, A119

Start Date: 9/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *V*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3043

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G  
2-Deburr and bevel ends for welding

*Ar 11.09.08*



110

0.00



*QC* Inspect part completeness to step on W/O

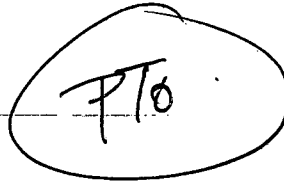
Memo

0.00

QC

Quality Control

*Pl 11.09.09*



120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802  
AR AL ROD Batch: *114514/117884*  
2-Grind Fwd End Cap weld flush

*Pl 11.09.09*



W/O: 73640		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-09-09	110	CHANGE TO QCB	NA	11-09-14	NA	NA	S. Woolley

Part No: D3043-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				1	0	BE 11/09/12	
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				21	27		
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				1	0		

11.09.12

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Large Fab	Large Fab	0.00				1	0		
Large Fab	Memo 1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR AL ROD Batch: <u>M114514</u> 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush	0.00							
170  QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
180  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

*11.09.13*  
*Ac 11.09.12.*

*Sum 10/13*

*Sum 10/13*

*(17)*  
*(24)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:				Stop	
Item Name: Step Weldment LH, A119					
Start Date: 9/8/2011	Start Qty: 1.00		Cust Item ID:		
Required Date: 9/15/2011	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

*IX Ø M-L 11/09/13*

200	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

*IX Ø M-L 11/09/13*

210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

*IX Ø M-L 11/09/13*

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*9:15*  
*320 °F*  
*9:45*

*M 117745*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date:	9/15/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Wing Walk as per dwg QSI005 4.4 Batch	118313 0.00							
	HandFinish	Memo							
	Hand Finishing								
230	QC3- Inspect Part Finish	0.00							
	QC	Memo							
	Quality Control								
240	Identify as per dwg & Stock Location:	0.00							
	Packaging	Memo							
	Packaging								

6 BL 11-9-13

1 HA of M 11/09/13

Packaging 11/14/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 9/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14

MF  
11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 08, 2011 1:22:36 PM

Page 1

Work Order ID: 73640

Parent Item: D3043-041

Parent Item Name: Step Weldment LH, A119

Start Date: 9/8/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

120

Each

189.2000

1

1



Step Extrusion

Location

Loc Qty

Loc Code

HALL

179.5

64409

6

68293

56.5

72131

117

WA

9.7

46910

2

66970

7.7



Ac 11.09.08

D2734

Manufactured

No

120

Each

74.0000

2

2



Step End Plate

Location

Loc Qty

Loc Code

WA

74

70701

29

73196

45



11.09.09

D3040-1

Manufactured

No

120

Each

22.0000

2

2



Mounting Lug

Location

Loc Qty

Loc Code

WA018

22

48239

22



11.09.09

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 2

Thursday, September 08, 2011 1:22:36 PM

Work Order ID: 73640



Parent Item: D3043-041



Parent Item Name: Step Weldment LH, A119

Start Date: 9/8/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3040-3

Manufactured No

100

Each

18.0000

2

2



Mounting Lug



*11.09.09*

Location

Loc Qty

Loc Code

WA018

18

48240

18

2

Thursday, September 08, 2011 1:22:37 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP  
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O 73640

RELEASED  
01.07.05

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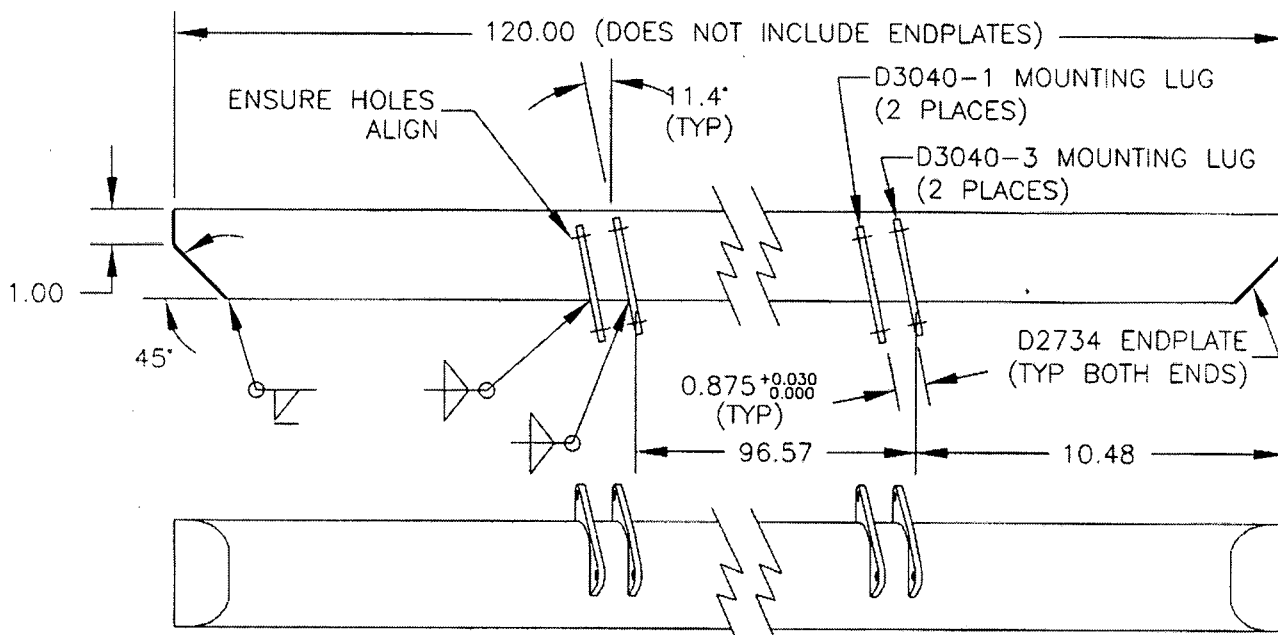
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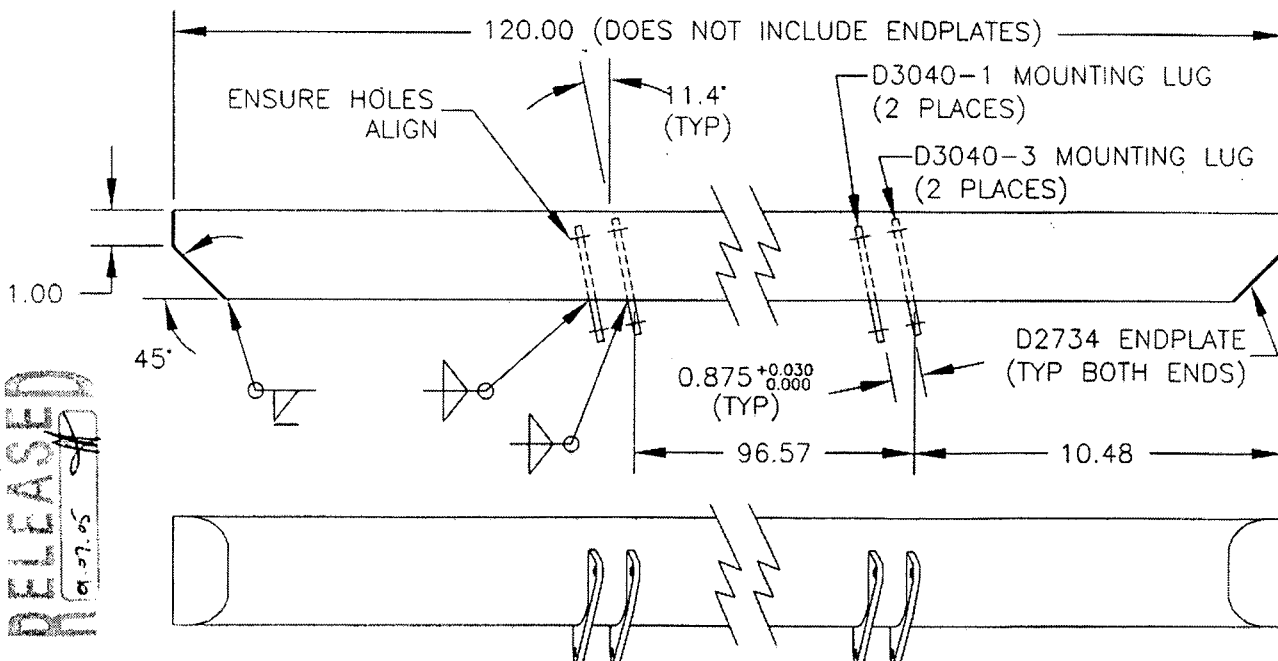
**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASE  
50.60

73640

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